Thursday, 3/30/2006 8:30:41 AM

IJser:

Kim Johnston

Process Sheet

KJ

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. : N/A

: Est:03.01.21/Remove step 6 (Deburr)

Job Number **Estimate Number** : 26411

: 10547 : N/A

P.O. Number This Issue

: 3/30/2006 : NC

Prsht Rev. : N/A First Issue

: 24566 **Previous Run**

Written By

Checked & Approved By

Comment

: MACHINED PARTS

Drawing Name

: END PLATE

: D30671

: N/A

: D3067 REV A

Part Number

Drawing Number

Project Number Drawing Revision

Material : 4/6/2006 **Due Date**

Qty:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

5052-H32 .063 Sheet

M5052H32S063 1.0



Total:

Comment: Qty.: 0.0656 sf(s)/Unit

> 5052-H32 .063 Sheet Material: 5052-H32 (QQ-A-250/8)

M5052H32S.063) or6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)

M16454 x

SHEAR

SHEAR

10.5000 sf(s)



Comment: SHEAR

Cut blanks 2.750" x 3.030" +/- 0.005

Grain along 2.750"

3.0

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio FA183 and Dwg D3067

4.0

QC2

INSPECT PARTS AS THEY COME OFF



Comment: [NSPEC] ARTS AS THEY COME OFF MACHINE



QC8 5.0

SECOND CHECK





Comment: SECOND CHECK

06/64/08 154

Dart Aerospace Ltd

DaitAc	OSpace	Ltu					
W/O:		WORK ORDER CI	HANGES			-	
DATE	STEP	PROCEDURE CHANGE	Ву	Ďate	Qtý	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	;						
					-		
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A: 🔼	Date: 🤇	X0/0Y/19
				N/C Close			
NCR:		WORK ORDER NON-CONF	ORMANCE (NC	R)			

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Varification	Annroval	Annewal				
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Chief Eng	Approval QC Inspector		
					•				
				*					
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Initial Action Description	STEP Description of NC Section A Initial Chief Eng Chief	STEP Description of NC Section A Chief Eng Corrective Action Section B Verification Section C Chief Eng Ch	STEP Description of NC Section A Chief Eng Chi		

NOTE: Date & initial all entries

Thursday, 3/30/2006 8:30:41 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: END PLATE Customer: CU-DAR001 Dart Helicopters Services Job Number: 26411 Part Number: D30671 Job Number: Seq. #: Description: **Machine Or Operation:** NC BRAKE BRAKE NC 6.0 Comment: NC BRAKE 154 Bend as per Dwg D3067 INSPECT WORK TO CURRENT STEP 7.0 QC5 Comment: INSPECT WORK TO NEXT STEP PACKAGING RESOURCE #1 8.0 PACKAGING 1 154 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WA DOCUMENT CONTROL 9.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

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W/O:			WC	ORK ORDER CHANG	ES				
DATE STEP		PR	OCEDURE CHA	NGE	Ву	Qty Approval Chief Eng / Prod Mgr		Approval QC Inspector	
		<i>-</i>							
Part No	:	PAR #:	Fault Cate	gory:					
	-					/C Closed:		_ Date:	
NCR:		•	WORK ORDI	ER NON-CONFORMA	NCE (NCF	2)			
DATE	OTED	Description of NC	Corrective Action Section			Verificat	tion	Approval	Approval
DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C Ch		QC Inspector	
							į		
,								•	

NOTE: Date & initial all entries

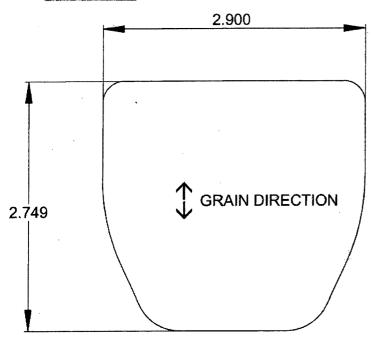
DART AEROSPACE LTD	Work Order:	26411
Description: End Plate	Part Number:	D3067-1
Inspection Dwg: D3067 Rev: A		Page 1 of 1

Inspection Dw	g: D3067	Rev: A				Page 1 of 1
		RST ARTICLE	INSPEC	TION CH	ECKLIST	
		X First A	r		totype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.900	+/-0.010	2.902				
2.749	+/-0.010	2.759				
		· · · · · · · · · · · · · · · · · · ·				
<u> </u>						
				· · · · · · · · · · · · · · · · · · ·		
Measured by: Audited by:					Prototype App	roval: N/A
Date:	06/04/07	Date:	06/00	107		Date: N/A
Rev Date	Change					evised by Approved
A 03.10.07					K	J/RF A

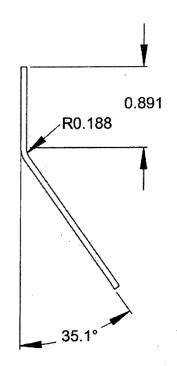
meas	area by.	7/2	Addition by:	(A)	· ictotype / tpp://ctail	
	Date:	06/04/07	Date:	26/04/07	Date:	N/A
Rev	Date	Change			Revised, by	
Α	03.10.07	New Issue			KJ/RF	- 7



DESIG	n	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECK	和	APPROVED	DRAWING NO.	REV. A SHEET 1 OF 1	
DATE	02.0	09.11	END PLATE	SCALE 1:1	
A	0	2.09.11	NEW ISSUE		



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

D3067-1 END PLATE

SHOP COPY

1) MACHINE PER DWG FILE "D3067-1.SLDPRT"

2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063) GINEERING OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061,T6S,063) LED COPY ALUMINUM SHEET, 0.063 THICK

SUBJECT TO AMENDMENT SUBJECT TO AMENDMENT

3) FINISH: NONE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

WORK ORDER

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